












Date:
User:Wednesday, 4/4/2007 9:01:16 AM
Kim Johnston

Process Sheet

Split
SB 07/03/14

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SCUFF PLATE
Job Number : 31604-2	
Estimate Number : 11952	
P.O. Number : N/A	Part Number : D206555003
This Issue : 4/4/2007	Drawing Number : D206-555 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 29020	Material : N/A
Written By : <u>Kim Johnston</u>	Due Date : 4/20/2007
Checked & Approved By : <u>Kim Johnston</u>	Qty: 10 Um: Each
Comment : est rev C 99.06.29 returned to electro polish DM Est Rev:D Now on Waterjet 06-10-25 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Form parts on hydraulic press as per Dwg. D206-555 using DT 8316-3	
2.0	M304S25GA 304/316 .020" Sheet
	 
Comment: Qty.: 0.4148 sf(s)/Unit Total: 4.1475 sf(s) 304/316 .020" Sheet 25GA Batch: <u>4153504</u> <u>SAD 07/06/11</u> 10	
3.0	WATER JET FLOW WATER JET
	 
Comment: FLOW WATER JET 1-Cut as per Dwg D206-555 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary <u>SAD 07/06/12</u> (10) <u>SAD 07/06/11</u> 10	
4.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAD 07/06/11</u> 10	
5.0	QC8 SECOND CHECK
	 
Comment: SECOND CHECK <u>7.06.12</u> (10)	

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 31604

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Finish form on bench forming Jig DT 8317-3

Polish with line mate

2-8-83 07/11/14
B 07/03/10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

OUTSIDE SERV 20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: 5046

Possible supplier: TQF Technologies

02/07/11/14

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

02/11/14

N/A
07/10/11

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

07/11/22 (x4)
01/4

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/22 (x4)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/11/22 (x4)

Process Sheet

✓ Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 31604

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

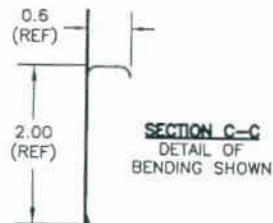
Comment: FINAL INSPECTION/W/O RELEASE

Done 4/11/23

Job Completion



4.11.23



DETAIL B
SCALE 1:1

REFER TO DETAIL B
FOR 1:1 SCALE

FLAT PATTERN

8.000

19.0
(REF)

8.000

Ø0.187
(3 PLACES)

2.7
(REF)

16.000 (REF)

NO. 31604
WORK ORDER
SUBJECT TO APPROVEMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
SHOP/DEPT
RETURN TO
ENGINEERING

D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)
D206-555-004 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

Hand Polish
using Line Mate
And S Fine Abrasives.

DESIGN JB	DRAWN BY S	DART DART AEROSPACE LTD WARRICKBURY, OXFORD, CANADA	REV. C
CHECKED PH	APPROVED PH		DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SHEET 3 OF 7	SCALE 2:3

05.10.12

RELEASED
06.09.14

Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: November 21, 2007

1270 Aberdeen St

Hawkesbury, Ontario

No. de certificat
Certification No.

K6A 1K7

tel.: (613) 632-5200

fax: (613) 632-1053

C121763

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
133024		NO. DE COM./P.O.# 5046	ELECTROPOLISH PER ASTM B912 REV.02
	4	D206-555-003 REF#B31604	
	10	D206-555-003 REF#B33109	
	10	D206-555-004 B30264 REF#B33110	

[Handwritten signature]

Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et specifications et sont en accord avec les exigences ci-inclus.

We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.

Signé pour et au nom de TQF Technologies Inc.
Signed for and on behalf of TQF Technologies Inc.



G. Persaud / G. McPhee

Total Quality Finishing